

January-24-12 9:00:35 AM

79222

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/01/2012 **Start Qty:** 14.00 ***14***

Cust Item ID:

Required Date: 06/03/2012 **Req'd Qty:** 14.00 ***11***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/01/24

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

**Insp.
Stamp**

Revision Nbr

D2892

B

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA082
2-Deburr

0.00

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79222

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

14

Cust Item ID:

14

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp. Stamp

0.00

130

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.
24h of cure time

AS 12 - 2 - V

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

12 02 07

Identify as per dwg & Stock Location: LG

0.00

170

Packaging

Memo

0.00

Packaging

As 12 - 2 - 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79222***79222***

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January-24-12 9:00:35 AM

Item ID: D2892-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 24/01/2012 Start Qty: 14.00

14

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/2/8

ME
12-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-24-12 9:00:39 AM

Page 1

Work Order ID: 79222

79222

Parent Item: D2892-1

D2892-1

Parent Item Name: Support

Start Date: 24/01/2012

Required Date: 06/03/2012

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP C02.11.26Added P/O KJ

IPP D 08.03.19 Re-format EC verified by: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077		Manufactured	No			110	Each	7.0000	0.5	7			

DSK077

D2892-1 TURNING DETAIL

**

Location

Loc Qty

Loc Code

MAT060

7

72724

7

7 ank 12/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79222
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: <i>KB</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.305	.305	.305	.305	.305
AC	0.040	0.060		.050	.050	.050	.050	.050
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.250	.250	.250	.250	.250
AF	0.188	0.193		.192	.192	.192	.192	.192
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.142	1.141	1.142	1.138	1.143
AI	0.454	0.474		.464	.464	.464	.464	.464
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.258	.258	.258	.258	.258
AM	1.663	1.683		1.673	1.673	1.673	1.673	1.673
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>anx</i>	Date: 12/02/09
Audited by: <i>SA</i>	Date: 12/2/6
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<i>SA</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	79222
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: <i>XB</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	8+0
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.305	.305	.305	.305	.305
AC	0.040	0.060		.050	.050	.050	.050	.050
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.250	.250	.250	.250	.250
AF	0.188	0.193		.192	.192	.192	.192	.192
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.134	1.142	1.144	1.145	1.138
AI	0.454	0.474		.464	.464	.464	.464	.464
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.258	.258	.258	.258	.258
AM	1.663	1.683		1.673	1.673	1.673	1.673	1.673
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>amf</i>	Date:	12/02/04
Audited by:	<i>JA</i>	Date:	12/2/6
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<i>JA</i>

DART AEROSPACE LTD		Work Order:	79222
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: KB	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1/	2/	3/	4/	5/
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	
AB	0.290	0.310		.305	.305	.305	.305	
AC	0.040	0.060		.050	.050	.050	.050	
AD	0.115	0.135		.125	.125	.125	.125	
AE	0.240	0.260		.250	.250	.250	.250	
AF	0.188	0.193		.192	.192	.192	.192	
AG	0.240	0.260		.250	.250	.250	.250	
AH	1.126	1.146		1.139	1.141	1.138	1.141	
AI	0.454	0.474		.464	.464	.464	.464	
AJ	0.240	0.260		.250	.250	.250	.250	
AK	0.053	0.073		.063	.063	.063	.063	
AL	0.257	0.262		.258	.258	.258	.258	
AM	1.663	1.683		1.673	1.673	1.673	1.673	
AN	0.053	0.073		.063	.063	.063	.063	
AO	0.022	0.042		.032	.032	.032	.032	
AP	2.779	2.789		2.784	2.784	2.784	2.784	
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: one Date: 12/02/04

Audited by: JS Date: 12/2/6

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED

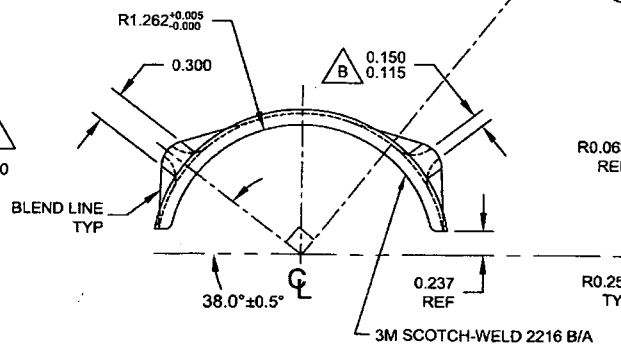
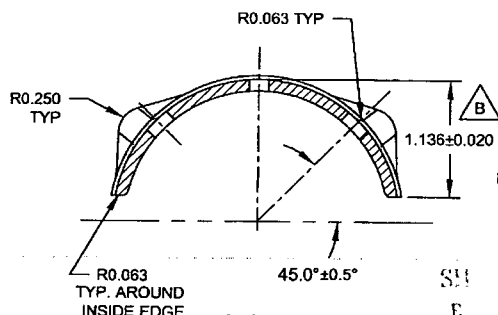
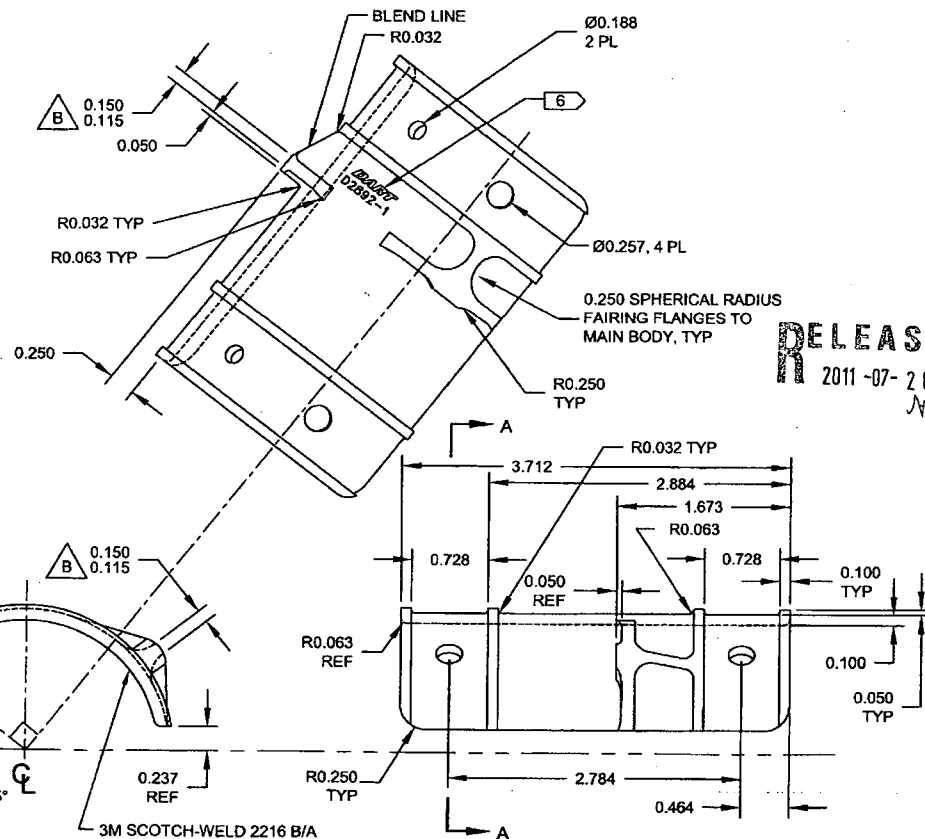
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.41 lb

8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



B	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION, UPDATE TOLERANCE (ZN D5-1,B5-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	90		
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2892
REV. B
SHEET 1 OF 1
TITLE: Ø2.500 SUPPORT
SCALE: NTS
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UNCONTROLLED
SUBJECT

NO 79222 M.L.J
12/01/24

D2892-1 SUPPORT

RELEASED
2011-07-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries